



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




# Work Order ID 64313

Thursday, December 02, 2010 8:57:29 AM

Page 2

Item ID:	D2583	Accept		Setup	Start	
Revision ID:						
Item Name:	Latch Bracket				Stop	
Start Date:	12/2/2010	Start Qty:	30.00		Cust Item ID:	
Required Date:	12/9/2010	Req'd Qty:	30.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00				(31)			
Brake NC	Memo Deburr Form on CNC Brake as per Dwg D2583	0.00		SO 10/12/06					
140  QC	QC5- Inspect part completeness to step on W/O	0.00				count (x31)			
Quality Control	Memo	0.00		SO 10/12/06					
150  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				31			
Hand Finishing	Memo	0.00							10-12-7

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Thursday, December 02, 2010 8:57:29 AM



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Item ID:	D2583	Accept		Setup	Start	
Revision ID:						
Item Name:	Latch Bracket				Stop	
Start Date:	12/2/2010	Start Qty: 30.00		Cust Item ID:		
Required Date:	12/9/2010	Req'd Qty: 30.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115951</i>	0.00				<i>31</i>	<i>18-12-8.</i>		
	Memo	0.00							
	START TIME: <i>12:00</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>12:30</i>								
170  QC Quality Control	QC3- Inspect Part Finish	0.00				<i>31</i>	<i>0</i>		<i>=&gt; M 10/12/08</i>
	Memo	0.00							
180  Packaging Packaging	Identify as per dwg & Stock Location: <i>17</i>	0.00				<i>10/12/09</i>	<i>51</i>	<i>(310)</i>	
	Memo	0.00							

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**NOTE:** Date & initial all entries

**Work Order ID 64313**

Thursday, December 02, 2010 8:57:29 AM

Page 4

Item ID: D2583

Accept

Revision ID:

Item Name: Latch Bracket

Start Date: 12/2/2010 Start Qty: 30.00

Required Date: 12/9/2010 Req'd Qty: 30.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/12/09 *[Signature]*  
PS 10-12-9  
①

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# Picklist Print

Thursday, December 02, 2010 8:57:33 AM

Page 1

Work Order ID: 64313

Parent Item: D2583

Parent Item Name: Latch Bracket



Start Date: 12/2/2010

Required Date: 12/9/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: C000.11.01 Removed P/O for Powder Coat- in house process DM  
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.040

Purchased

No

100

sf

19.3234

0.1169

3.691579

3.8



FB 10-12-6

5052-H32 .040 Sheet

Location

Loc Qty

Loc Code

MAT

16.3

114488

16.3

MAT23

3.0234

109058

1.6234

113123

1.4

114488

31

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**DART**

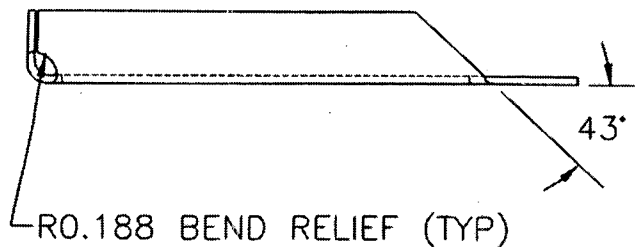
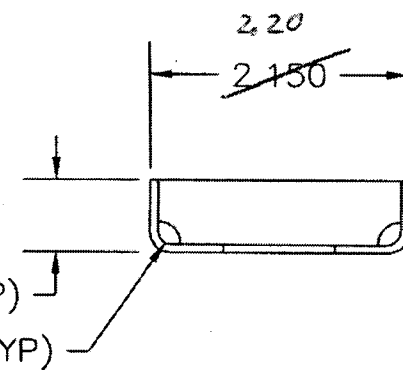
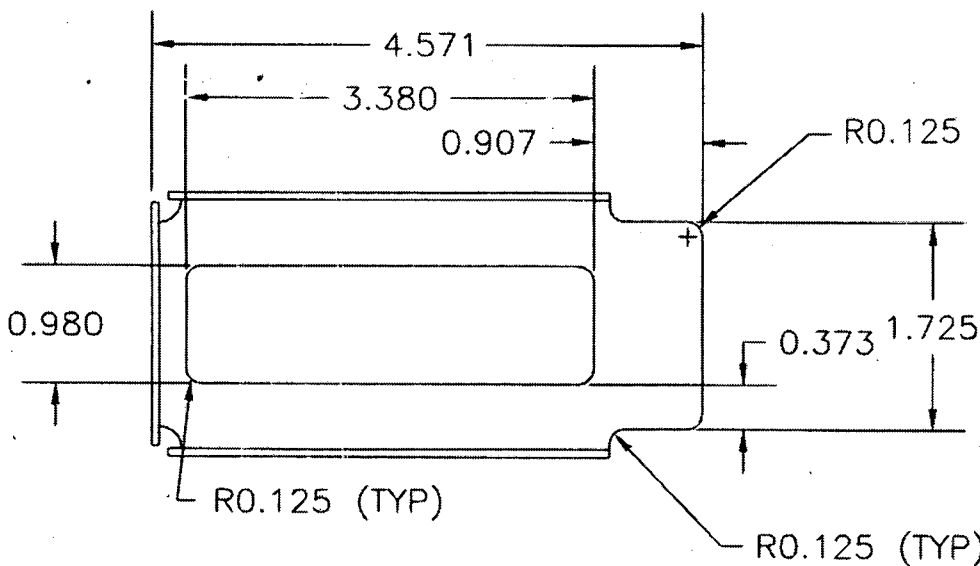


RELEASED  
KE 99.02.25

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44313

*BS10-12-1*

*KE 99.02.26*



DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	<i>CP</i>	APPROVED	<i>KE</i>	HAWKESBURY, ONTARIO, CANADA
DATE	99.02.22	DRAWING NO.	D2583	REV. B
		TITLE	LATCH BRACKET	SHEET 1 OF 1
			NEW ISSUE	SCALE
			CHANGE OF FINISH (PER TSR A887)	2:3

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED